

Work Order ID 74972***74972***

Page 1

Thursday, October 13, 2011 2:38:05 PM

Item ID: D3230-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Wedge Assembly

Start Date: 10/13/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *ME*Date: *11-10-13*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3230

Rev C

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut 3/4 x 3/4 square tubing as per Dwg D3230
2- Drill and c/sink holes
3- cut mesh as per dwg
4 -Deburr & Remove all Markings From Material
5-Weld bushings and fabricate basket wedge assembly as per D3230
A/R SS ROD Batch: *117884*

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

BF
*11.10.18**BF*
*11.10.18**1* *Ø*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 74972

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 Start Date: 10/13/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/14/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

140 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

140

Powdercoat

Powder Coating

Memo

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

**** if necessary****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

Sulco

NO M-11/10/18

M 11/8/15

*11:35
400°F
12:05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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1

Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

1 BR 11-10-18.

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

PM 74971Pepper @

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

11/10/18 DMF
11-10-18

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, October 13, 2011 2:38:04 PM

Page 1

Work Order ID: 74972

Parent Item: D3230-041

Parent Item Name: Basket Wedge Assembly

Start Date: 10/13/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:D 09-02-25 rev.c as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2232-3 Basket Hinge		Manufactured	No			110	Each	5.0000	2	2		10-17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST		5							
				72929		5							
✓ D2327-3 Spacer Bushing		Manufactured	No			110	Each	18.0000	2	2		10-17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		18							
				71971		1							
				72963		17							
✓ D3759-1 Bushing		Manufactured	No			110	Each	87.0000	5	5		10-17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		85							
				72316		85							
				WA005		2							
				86489		2							
✓ M304EX0.75-16F Expanded Metal Flat SS		Purchased	No			110	sf	779.7855	5.15	5.4210526		10-17	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		779.78548							
				117197		102.9036							
				117896		53.3264							
				118153		82.2683							
				118248		33.0983							
				118597		73.01888				5.4210			
				118955		115.17							
				119180		320							

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 74972

Parent Item: D3230-041

Parent Item Name: Basket Wedge Assembly

Start Date: 10/13/2011

Required Date: 10/14/2011

Start Qty: 1.00

Required Qty: 1.00

✓ M304TS0.750W.065
304 SQ Tube .75x.75x.065W

Purchased

No

110

f

686.1922

25.2966

26.628

Pl 11.10.14

Location

Loc Qty

Loc Code

MAT018

664.5280585

117636

67.9987

118773

596.529359

26.628

WA

6.0667

118181

6.0667

WA007

15.5974906

116267

14.628472

116763

0.9690186

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Shop Packet Print

Page 2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

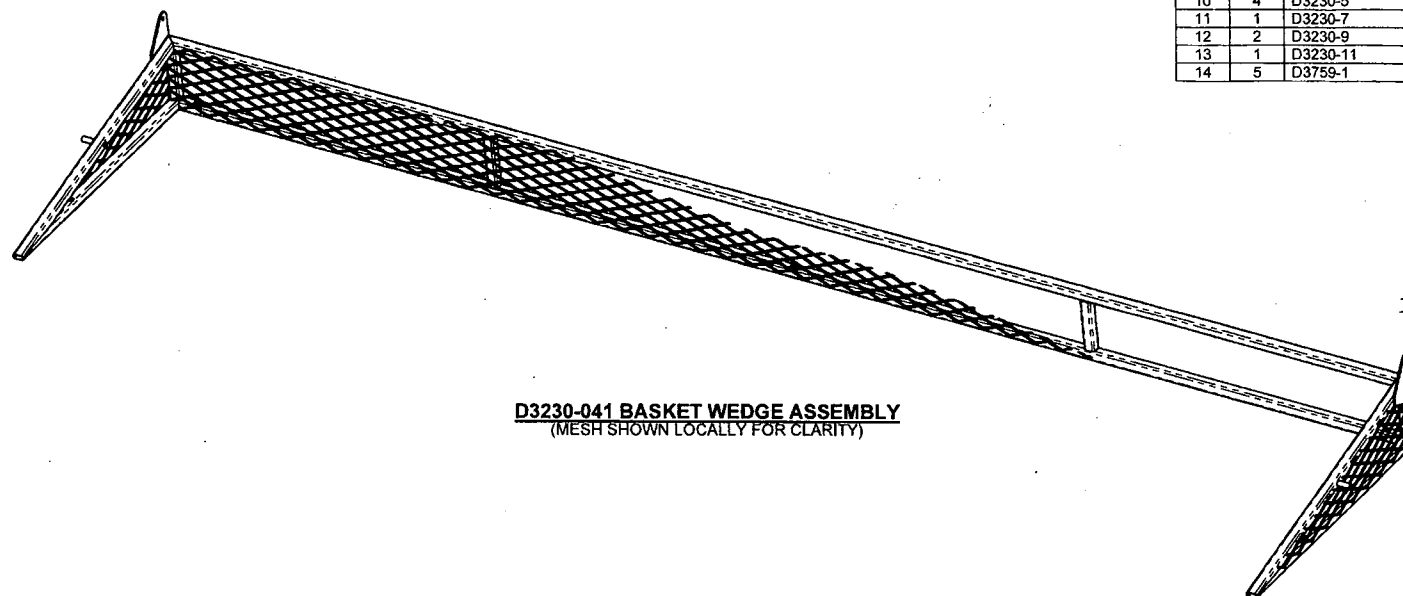
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	D3230-041	BASKET WEDGE ASSEMBLY
3	1	D2221-1	RIB
4	2	D2232-3	BASKET HINGE
5	2	D2327-3	SPACER BUSHING
6	1	D3230-1	RIB
7	1	D3230-2	RIB
8	1	D3230-3	RIB
9	1	D3230-4	RIB
10	4	D3230-5	RIB
11	1	D3230-7	RIB
12	2	D3230-9	SIDE MESH
13	1	D3230-11	FRONT MESH
14	5	D3759-1	BUSHING



D3230-041 BASKET WEDGE ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

74970

RELEASED
09.02.19 CP
PER ECN 09-534

C	REDESIGN (SEE NCR 09-010); REFORMAT DRAWING TO CURRENT STANDARDS	MB	09.01.27
B	15.75 WAS 16.00; REMOVE D2581; ADD VIEW B-B; D2327-3 ADDED	CB	06.11.10
A	NEW ISSUE	CP	03.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	JP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D3230	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET WEDGE ASSEMBLY	NTS
DATE	09.01.27	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3230-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 19.8 lbs
- 8) WELDING: PER DART QSI 004

8 7 6 5 4 3 2 1

Dart Aerospace Ltd

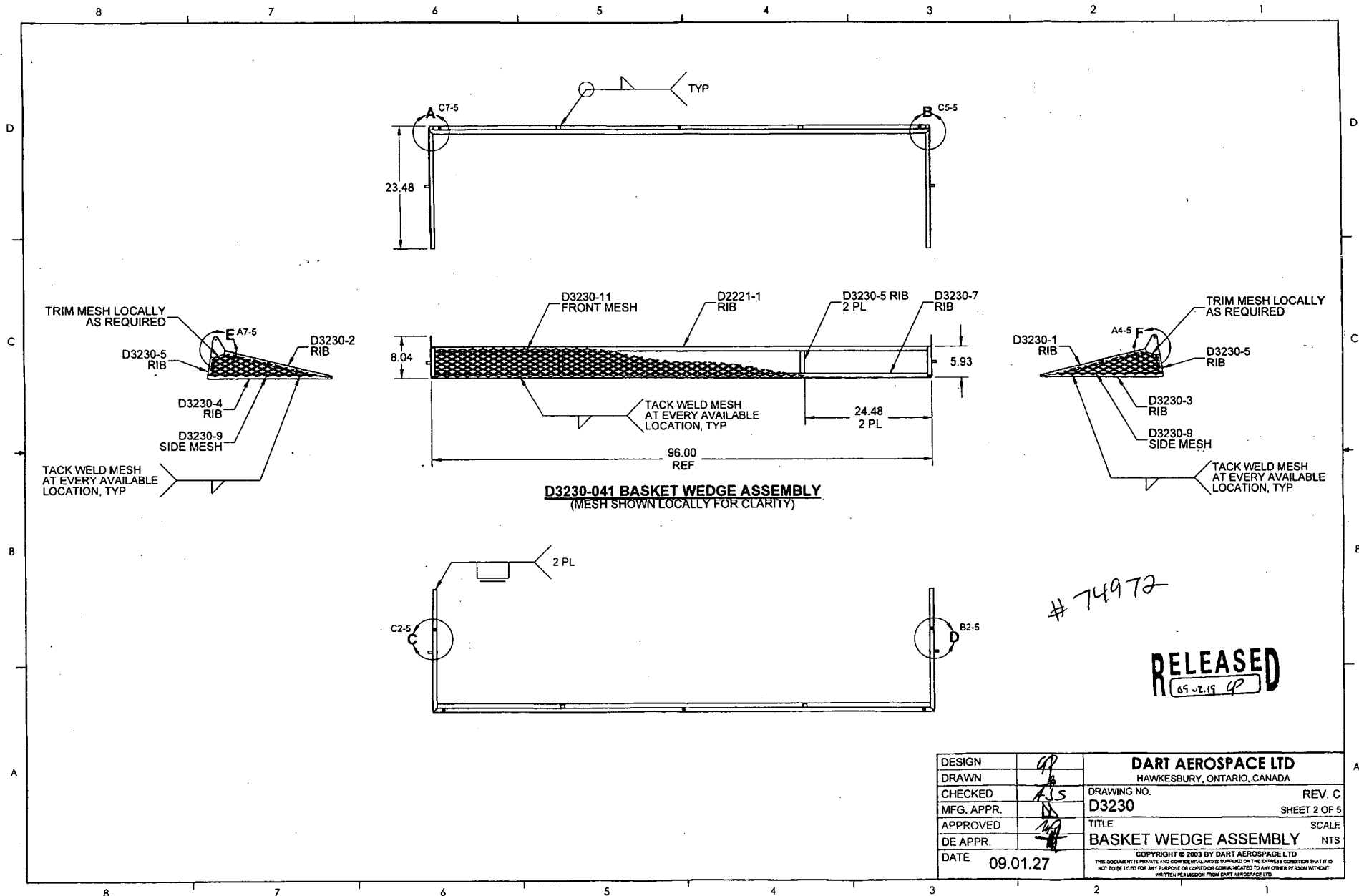
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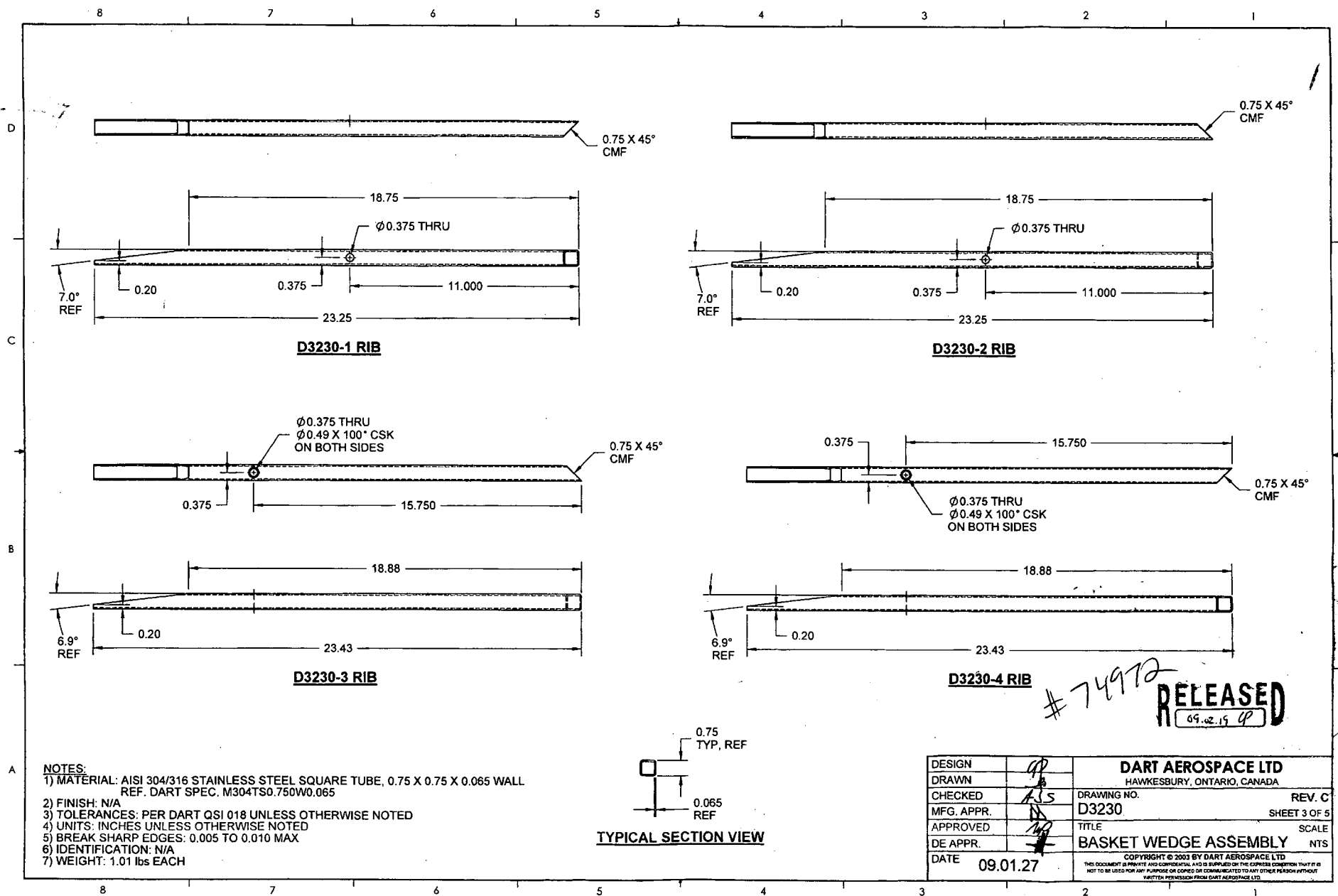
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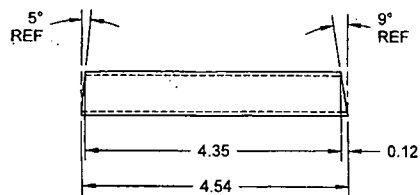
#74972
RELEASED
69.02.15 4P

DESIGN	4P	DART AEROSPACE LTD	
DRAWN	4P	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4P	DRAWING NO.	REV. C
MFG. APPR.	4P	D3230	SHEET 3 OF 5
APPROVED	4P	TITLE	SCALE
DE APPR.	4P	BASKET WEDGE ASSEMBLY	
DATE	09.01.27	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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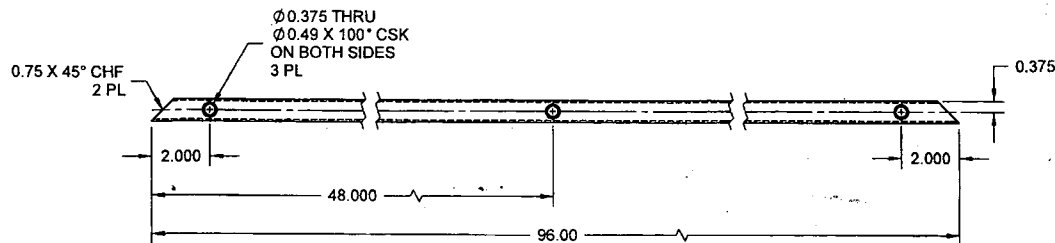
140
A
REEL 4
B7A C
RECEIVED

RECEIVED
JUL 19 1960

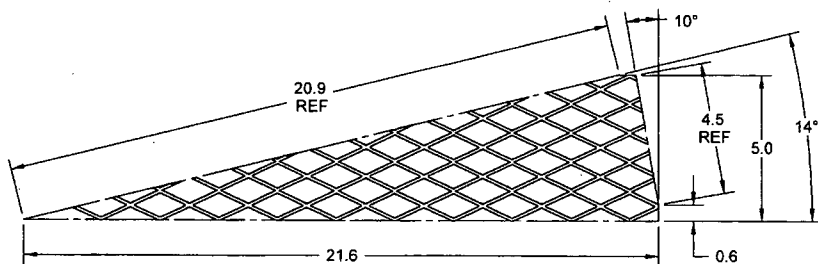
B



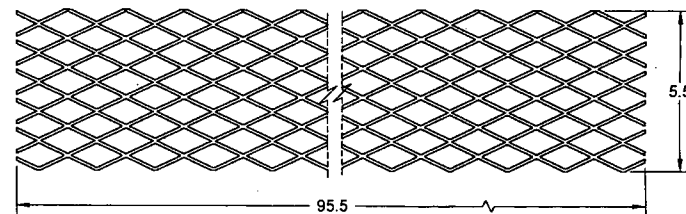
D3230-5 RIB



D3230-7 RIB



D3230-9 SIDE MESH



D3230-11 FRONT MESH

74972

RELEASED
09.02.19

NOTES:

1) MATERIAL:

D3230-5/-7: AISI 304/316 STAINLESS STEEL TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
D3230-9/-11: 3/4-16F EXPANDED STAINLESS STEEL
REF. DART SPEC. M304EX0.75-16F

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

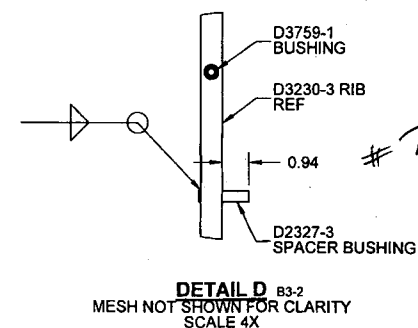
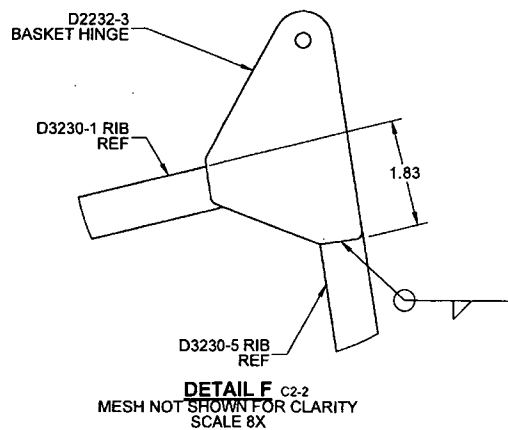
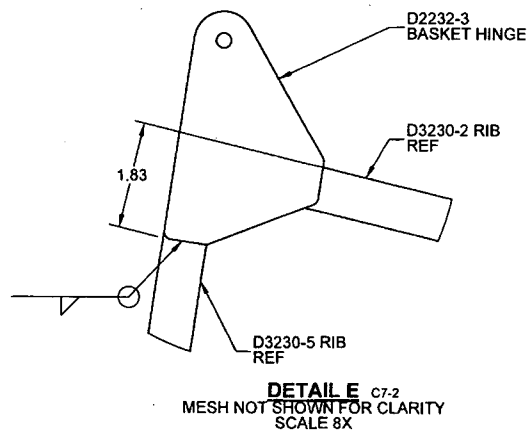
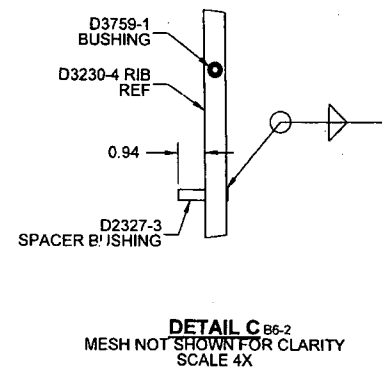
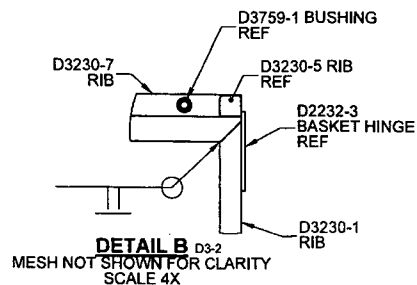
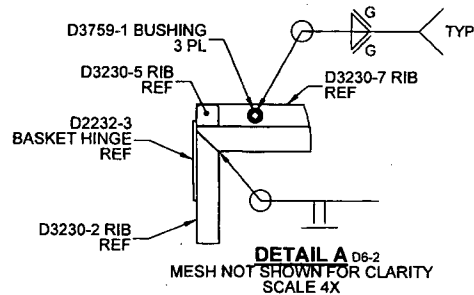
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

**7) WEIGHT: D3230-5 = 0.21 lbs; D3230-7 = 4.55 lbs
D3230-9 = 0.20 lbs; D3230-11 = lbs**

DESIGN	<i>DA</i>	DART AEROSPACE LTD	
DRAWN	<i>DA</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>DA</i>	D3230	SHEET 4 OF 5
APPROVED	<i>DA</i>	TITLE	SCALE
DE APPR.	<i>DA</i>	BASKET WEDGE ASSEMBLY	
DATE	09.01.27	NTS	
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RELEASED
09-01-27

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CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	DP	D3230	SHEET 5 OF 5
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	BASKET WEDGE ASSEMBLY	NTS
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